

Date: Friday, 2/23/2007 8:32:58 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BAFFLE ASSEMBLY
Job Number : 30902	
Estimate Number : 11264	
P.O. Number : N/A	Part Number : D3276041
This Issue : 2/23/2007 S.O. No. : N/A	Drawing Number : D3276 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : 29422	Material : N/A
Written By : <u>                    </u>	Due Date : 3/28/2007 Qty: 5 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : Est Rev: A New Issue 05-12-06 JLM	
Est Rev: B Now on Waterjet 06-09-06 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 1.0715 sf(s)/Unit Total : 5.3576 sf(s)  
 Material: 6061-T6 (QQ-A-250/11) 0.040" thick  
 (M6061T6S.040)  
 Batch: M19380 ml 07 02 27 (5)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3276  
 Dwg Rev: B ml 07 02 27 (5)  
 Prog Rev: B  
 2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/02/27 (5)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr SAB 07/02/27 (5)

2-Roll as per Dwg D3276

SAB 07/03/21 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BAFFLE ASSEMBLY

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Part Number: D3276041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276, check with template DT8825

SB 07/03/22

⑤

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/03/22

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ML

07-03-26

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M1103706

ML

SB 07-03-27

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/03/30

11.0

D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total : 11.2500 f(s)

Pick:

Qty Part Number

Description Batch

27.0" D2464

Neoprene Seal

B 30681

SB 07/03/30

12.0

D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3276-3

Decal

B 30916  
B 29440

SB 07/03/30

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

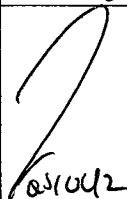


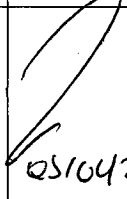

Assemble as per Dwg D3276

SB 07/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/05

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070302	60	Joggle was made opposite to dwg.	 05/04/02	Re-do the joggle as per dwg. see NCR #152	 07/04/05	 07/04/05	 05/04/02	 0703-02

NOTE: Date & initial all entries

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Part Number: D3276041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/03 (5)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/04/03 (5)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

Job Completion



07/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

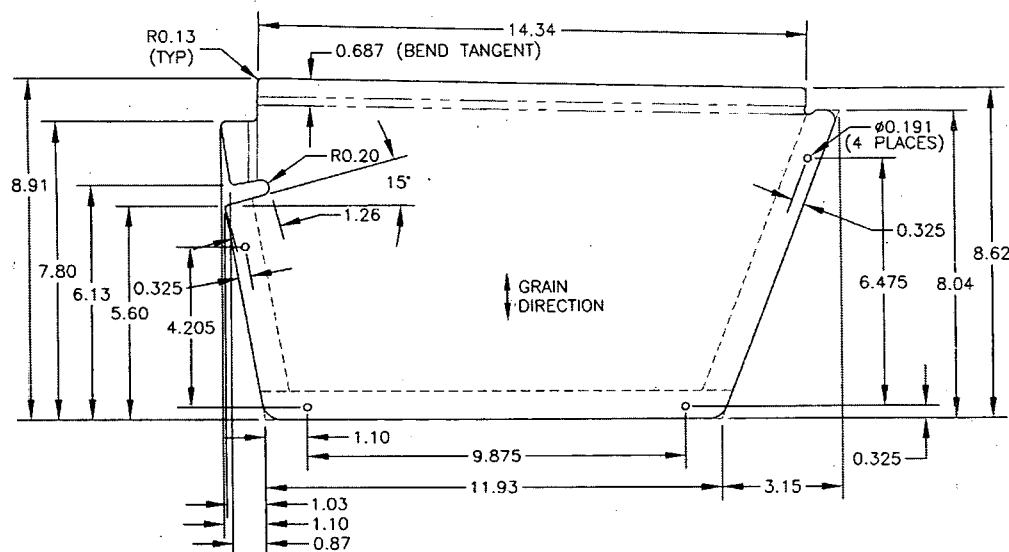
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

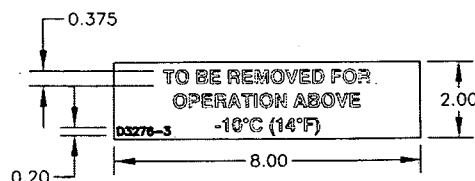
**NOTE:** Date & initial all entries





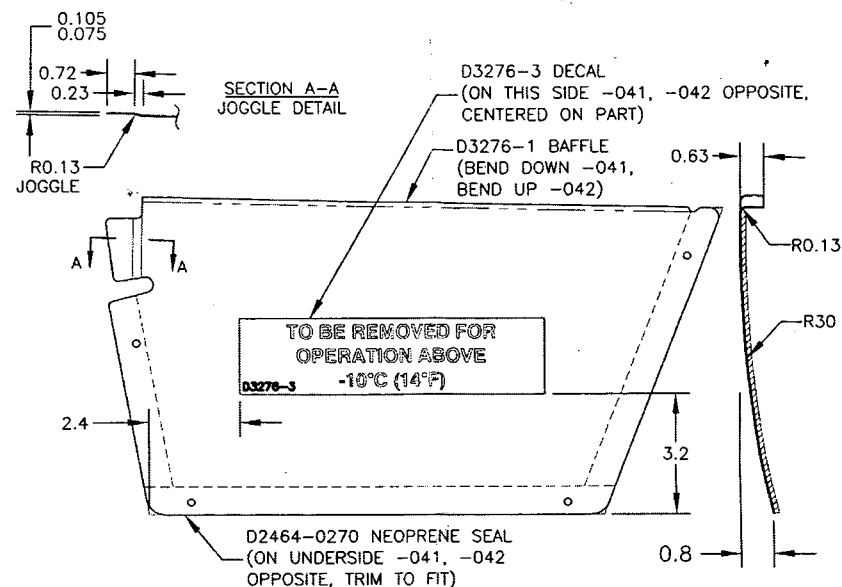
#### D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)  
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)

#### D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

RELEASED  
05.01.07

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B	05.01.25	LABEL NOW -10°C; CURVE PART	
A	05.01.07	NEW ISSUE	
DESIGN	CP	DRAWN BY	CP
CHECKED	#	APPROVED	#
DATE	05.01.25	DRAWING NO.	D3276
		TITLE	BAFFLE ASSEMBLY
		REV. B	SHEET 1 OF 1
		SCALE	1:3

**DART** DART AEROSPACE LTD.  
WILKESBURY, ONTARIO, CANADA

129-112-1110